

(19)



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(11)

EP 1 149 426 B1

(12)

EUROPEAN PATENT SPECIFICATION

(45) Date of publication and mention
of the grant of the patent:
17.09.2003 Bulletin 2003/38

(51) Int Cl.7: **H01M 2/16**, H01M 6/04,
H01M 10/24

(21) Application number: **99967430.2**

(86) International application number:
PCT/US99/30275

(22) Date of filing: **17.12.1999**

(87) International publication number:
WO 00/036672 (22.06.2000 Gazette 2000/25)

(54) **FORMED IN SITU SEPARATOR FOR A BATTERY**
IN SITU HERGESTELLTER BATTERIESEPARATOR
SEPARATEUR POUR BATTERIE FORME IN SITU

(84) Designated Contracting States:
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE

(30) Priority: **18.12.1998 US 216571**

(43) Date of publication of application:
31.10.2001 Bulletin 2001/44

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Description

[0001] This invention relates to batteries and in particular to separators for alkaline cell.

[0002] Alkaline batteries are generally cylindrical in shape and include an annular cathode disposed between the outer casing of the battery or can, and the anode material which occupies a cylindrical volume having a longitudinal axis generally coincident with that of the battery and can. Located between the cathode and the anode material is a separator which electrically insulates the cathode from the anode material, but which absorbs electrolyte and allows water transport and ion transfer between the electrodes. Heretofore, the separators used in alkaline batteries have generally been limited to commercially available battery separator papers and cellophane films.

[0003] While conventional battery separator paper has proven satisfactory, it would be desirable to provide methods and materials which would allow the separator to be installed at a lower cost using a simplified process and apparatus. In particular, the equipment used to cut and place the paper separators into the batteries is relatively complicated and expensive. Additionally, preparing the equipment used to cut and place the paper separators into the batteries requires sampling of the paper used to form the separators and adjustments of the equipment depending on the particular properties of the paper being used.

[0004] Another problem with the use of paper separators is that process reliability is sensitive to the internal diameter of the cathode. For example, variations in the internal diameter of the cathode along the longitudinal length of the battery can result in areas wherein the separator does not intimately contact the cathode. Also, changes in anode basket volume affect cell performance. As a result, the interfacial area for ionic transport may be substantially reduced as compared with a battery having a separator basket with an internal diameter which does not vary along either the longitudinal or radial direction and wherein the separator is substantially in continuous contact along the entire internal cylindrical surface of the cathode.

[0005] Another problem with paper separators is that because of the relatively complicated manipulations required to place the separators into the batteries, long process cycle times are required and process capability is generally low and varies widely between machines and even for any particular machine.

[0006] A still further disadvantage with paper separators is that the paper takes up a substantial amount of volume within the cell, which, in turn, requires a substantial amount of electrolyte to wet the separator. Paper separators work optimally when wet and less efficiently when only damp.

[0007] Also, the paper does not intimately contact the cathode over the entire cathode/separator interface, especially at the bottom of the separator where the folds

occur, creating unused volume within the cell. Side seams of conventional paper separators also consume cell volume. A still further disadvantage with conventional paper separators is that the defect rate is greater than desired.

[0008] An alternative method for preparing an electrochemical cell which does not involve the use of a paper separator involves forming a polystyrene separator by placing a predetermined amount of polystyrene solution directly on the surface of a cathode and removing the organic solvent, thereby leaving a substantially continuous coating on the surface of the cathode. This method is generally undesirable and impractical because it typically requires placement of a reinforcing means on the surface of the cathode before application of the solution containing polystyrene, and requires evaporating large quantities of volatile organic solvents such as methylene chloride, tetrahydrofuran, ethyl acetate, acetone, benzene, toluene, and trichloroethylene. Placing of a reinforcing means on the surface of the cathode adds to the cost of the battery and requires complicated automation comparable to that required for automatically incorporating a paper separator into a battery. The use of volatile organic solvents is extremely undesirable due to health related issues (e.g., toxicity), safety related issues (e.g., flammability) as well as the difficulty and expense involved in avoiding environmental contamination. Some solvents, if not entirely removed, can detrimentally affect cell performance.

[0009] It would therefore be desirable to be able to provide an improved method of constructing a battery using a separator which is installed within the battery without folding operations, and elimination of the various problems enumerated above relating to the use of conventional paper separators and polystyrene separators. It would also be desirable to be able to provide batteries having improved volumetric efficiency, improved solvent transport characteristics across the separator, and improved ionic conductivity across the separator.

[0010] We have now found that the above objectives may be achieved, and the disadvantages with paper separators enumerated above may be overcome, by a battery having a separator formed directly on an electrode by applying a coating composition comprising a polymer or gel dispersed in a polar solvent to the surface of the electrode and solidifying materials in the applied coating composition.

[0011] Accordingly, in a first aspect, the present invention provides a battery comprising first and second electrodes, an alkaline electrolyte, and an ionically conductive separator disposed between the electrodes, the separator being formed by applying a coating composition to the surface of at least one of the electrodes and solidifying material contained in the coating composition, the coating composition comprising a gel or polymer dispersed in a polar solvent, wherein the separator has a solvent content greater than 50% by weight.

[0012] In a second aspect, the present invention pro-

vides a method of providing a separator on an electrode for an alkaline battery, comprising:

applying a liquid aqueous coating composition to an electrode surface; the coating composition comprising a gel or polymer dispersed in a polar solvent; and solidifying the coating composition on said electrode surface to form a separator membrane, wherein the separator has a solvent content greater than 50% by weight.

[0013] The present invention will be further understood by reference to the drawings, in which:

Figures 1-3 illustrate a method for forming a separator directly on a cathode by applying a coating composition to the cathode surface and allowing the coating composition to solidify; and Figure 4 illustrates an alternative apparatus for applying a coating composition to a cathode surface of an alkaline battery.

[0014] The invention encompasses batteries having a separator which is formed directly on an electrode by applying a polar solvent based coating composition, such as an aqueous coating composition, to the electrode surface and allowing the coating composition to solidify. Although the invention will be primarily described with respect to cylindrical batteries, it is not limited to cylindrical shaped batteries, but instead may be applied to batteries of various other shapes.

[0015] The expression "polar solvent based coating composition" refers to a composition which can be applied to a surface using liquid coating techniques, and wherein the solvent portion of the composition is comprised mostly of polar molecules. Examples of polar solvents include water, alcohol, and sulphuric acid. The invention hereinafter will, in general, be described with respect to aqueous coating compositions, it being understood that other polar solvents may be employed in accordance with the present invention.

[0016] The method involves using any of various conventional coating application techniques including, but not limited to, centrifugal casting, spinning disk coating, spray coating, slush moulding, electrostatic spraying and thermoforming. Other application techniques which may be used include inverted can spray coating wherein the coating composition is sprayed vertically upwardly into an inverted battery can containing a cathode, dip coating wherein the battery can containing the cathode is filled with the coating material and excess coating material is subsequently poured out of the battery can, pad coating wherein an expendable cylindrical pad is dip coated with the coating composition and pressed against the inner surface of the cathode to transfer the coating composition to the cathode surface, brush coating, roll coating, slot extrusion coating wherein the coat-

ing composition is applied to the cathode surface from an extrusion die, vacuum forming, blow moulding, and pour-in-place gelling wherein a gel precursor is poured into the cathode and a forming plug is thereafter inserted into the cathode followed by rapid curing, or a combination of these techniques. Presently preferred coating application techniques include ram moulding, centrifugal casting, and spray coating. Thus, the separator will preferably be in substantially continuous contact with the surface of the electrode upon which it is formed.

[0017] The ram moulding technique for applying the coating composition to the internal surfaces of the cathode is illustrated in Figures 1-3. As shown in Figure 1, the coating composition 10 is introduced into the bottom of a battery 12 having a cathode 14. Next, as shown in Figure 2, a forming ram 16 is introduced into the cathode to cause the coating composition to flow up between the ram and the inner surface of the cathode. After the coating composition solidifies or sets, the ram 16 is removed from the battery 12, leaving a separator 18 which is formed directly on the cathode.

[0018] In Figure 4, there is shown an alternative forming ram 20 having an internal conduit or bore 22 with an outlet port 24 at a lower end thereof. The forming ram 20 is first inserted into the battery 12 having a cathode 14 as shown in Figure 4. Thereafter, coating composition is introduced into the bottom of the battery through conduit 22 from outlet port 24. The coating composition flows through the ram, into the bottom of the battery, and up into the annulus between the ram and the inner surface of the cathode 14.

[0019] The ram moulding technique is believed to have several potential advantages. First, the shape of the formed separator 18 can be controlled by controlling the dimensions of the ram and the cathode internal diameter. Variations in temperature, viscosity, and solids loading in the liquid coating composition can be tolerated. This allows refinements in the coating composition to be made without changing the application process. The ram design can allow the shape of the separator to be tailored to improve performance characteristics. For example, the edges of the ram can be chamfered to decrease stress risers in the separator membrane. Also, the thickness of the membrane can be varied at different locations. The ram geometry allows the coating composition to be accurately applied over the top of the cathode shelf 26, along the sides 28, and on the bottom surface of the can. The anode volume formed by ram moulding can be very accurately controlled as compared with conventional batteries having a folded paper separator. The ram moulding technique is well suited to continuous automated production.

[0020] Another desirable technique for applying the coating composition to the inner surface of the cathode is centrifugal casting or spin coating. This technique involves first introducing the coating composition into a cathode cup disposed in and integrally connected to a cylindrical can. Thereafter, the cathode cup and cylin-

drican can are rotated at a high speed, or may already be rotating at a high speed when the material is introduced. As the cathode rotates, the material flows up along the internal surface of the cathode and solidifies or cures in place. The axis of rotation of the cylindrical can in which the cathode is disposed may be at any angle between and including a vertical axis and a horizontal axis. The can may be inverted such that gravitational acceleration assists the flow of coating composition out of the can.

[0021] Centrifugal casting is believed to have several advantages including even coating of the internal cathode surface regardless of surface irregularities on the cathode surface, filling of voids in the cathode surface such as where the cathode material spalls off during cathode moulding, and the ability to provide fixed or predetermined separator material volume. The centrifugal casting technique is tolerant to loose particles of cathode material left from cathode moulding. Another advantage of centrifugal casting or spin coating is that the internal surface of the separator will be very smooth.

[0022] Another desirable technique for applying the coating composition to the internal surface of the cathode is spray coating. With this technique, the liquid separator coating composition is sprayed onto the surface of the cathode and solidifies or cures in place. A major advantage of the spray coating process is its mechanical simplicity.

[0023] The aqueous separator coating composition may be an aqueous solution, gel, dispersion, slurry, or combination thereof which can be applied in liquid form using liquid coating application techniques, and which will solidify to form a separator directly on the cathode surface. Solidification of the coating composition refers to any process of drying, curing, gelling, cross-linking, polymerisation, freezing (*i.e.*, thermal solidification), or combination thereof which results in a stable electrically insulating barrier which will allow ionic transport between the electrodes and will adhere to the cathode during the production and useful life of a battery.

[0024] The solidified coating is preferably less than 510 μm (0.020 inches) thick, more preferably less than 130 μm (0.005 inches), with thinner coatings being desirable to maximise anode basket volume. The separator coating compositions preferably smooth out or fill any surface irregularities in the cathode surface and preferably have controllable thickness, including uniform and variable thickness.

[0025] An advantage with the formed *in situ* separators is that they are in intimate and complete contact with the electrode surface on which they are formed, *i.e.*, the separator is in substantially continuous contact with the surface of the electrode upon which the separator is formed. This differs significantly from paper separators which normally have significant areas which are not in contact with adjacent electrode surfaces. The improved contact provided by the *in situ* formed separators provides enhanced ion transport properties and im-

proved cell performance. The formed *in situ* separators can be made thinner than paper separators and can therefore occupy less space than a paper separator, thereby allowing more space in a battery for electrode material, and hence enabling improved battery performance. For example, the formed *in situ* separators may be employed to provide batteries in which the separator occupies less than 10% of the cell volume.

[0026] The solidified or cured separators should be mechanically tough, resistant to mechanical shock and not easily ruptured or damaged once cured. The resulting separator should also exhibit sufficient tear resistance to prevent tears across gaps between the cathode rings, cathode-to-can interfaces, or the surfaces of the anode. The separator coating composition should also solidify or cure to form a separator membrane having sufficient elasticity to sustain at least 25 % expansion of the cathode dimensions during discharge without tearing or separating from the electrode. The separator should also exhibit sufficient penetration resistance to resist penetration by zinc dendrites and should not provide a path for formation of zinc dendrites as do paper separators. The compression strength of the separator should be sufficient to prevent squeeze-out of liquid under full compression between a discharged anode and cathode. The separator should retain efficient mechanical properties throughout the operating temperature range of -20°C to 71°C, but also -40° to 85°C abuse temperatures.

[0027] The separator should also exhibit high retentiveness of electrolyte solution, even under compression and when either the anode or cathode are dried out, *i.e.*, the separator should be the last component to dry out during cell discharge. The separator must remain dimensionally stable in the presence of 45 % potassium hydroxide, and should not swell or shrink in the presence of water or potassium hydroxide and retain mechanical integrity. Further, the separators should preferably adhere to ring moulded, and impact moulded electrodes. The separators should also preferably adhere to rod-shaped, ring-shaped, strip-shaped, washer-shaped, and other shaped electrode surfaces.

[0028] In addition to the above mechanical requirements, the separator should exhibit certain electrical properties. First, the separator should not be electrically conductive, *i.e.*, it should act as an electrical insulator between the anode and cathode. The separator should maintain the electrical insulating characteristics over the projected life of the battery, which is at least about 5 years. The separator should also exhibit high ionic conductivity which meets or exceeds the hydroxyl ion flux density of the anode at the anode/separator interface, and which meets or exceeds the hydroxyl ion flux density of the cathode at the cathode/separator interface, *i.e.*, the separator should not be rate limiting. The separator should also have surface-to-surface ion conducting pathways, even in partially dehydrated condition.

[0029] The separator should also exhibit certain

chemical properties. First, the separator must be chemically stable or inert (i.e., must not decompose) in a 45 % potassium hydroxide solution. The separator should also exhibit chemical stability under a potential difference of up to 2 volts. The separator should also exhibit high gas permeability. In order to prevent local conditions favourable to zinc oxide precipitation, the separator should exhibit good shorting resistance. The separator must not cause corrosion of nickel plated steel at the cathode potential, and should exhibit minimum permanent bonding of electrolyte and water. The separator should also be resistant to catalytic decomposition by the metals used in the construction of the battery.

[0030] Water and ionic transport properties are also an important consideration. Water should readily diffuse through the separator so that small concentration gradients will result in high diffusion rates. Poor diffusion would result in cell polarisation under heavy drain. The separator must pass hydroxyl ions from cathode to anode and must pass potassium ions from anode to cathode. The pathway for ion transport should be somewhat tortuous. A suitable transference number of hydroxyl ion in potassium hydroxide is 0.73. The hydration number of potassium ion should be from about 1 to about 2. The separator should act as a barrier to prevent movement of electrode materials from the cathode to anode and from the anode to the cathode. Desirably, the coating compositions should offer the ability to tailor the transport characteristics.

[0031] The coating compositions of this invention solidify or freeze to form an aqueous gel separator having a solvent content greater than 50%, preferably greater than 90%, by weight. This high solvent content allows the separator to behave as an electrolyte reservoir.

[0032] It is believed that a wide variety of aqueous gels, and polymer dispersions can be formulated to achieve the desired separator characteristics. Examples of coating compositions which have been found to be suitable for forming a separator directly on the surface of a cathode include seamless gels comprising kappa-carrageenan, hydroxyethyl cellulose, and a blend of kappa-carrageenan and hydroxyethyl cellulose. Other suitable compositions may include lambda- or iota-carrageenan, other hydroxyalkyl celluloses such as hydroxymethyl- and/or hydroxypropyl cellulose, and combinations thereof. For example, kappa-carrageenan forms a strong film when cast as a 2-5 weight percent film with water. Hydroxyethyl cellulose cross-linked with vinyl sulphone forms a strong gel with very high ionic conductivity. However, separators formed from kappa-carrageenan alone are not as strong as would be desired, and separators cast from hydroxyethyl cellulose alone exhibit shrinkage which is generally more than would be desired for AAA and larger size cells, but is acceptable for smaller cells. Other coating compositions which may be employed include aqueous compositions containing polyvinylpyrrolidone, such as compositions comprised of carrageenan (e.g., kappa-, lambda-, and/

or iota-carrageenan) and polyvinylpyrrolidone.

[0033] It has been discovered that separator coating compositions containing a blend of kappa-carrageenan and hydroxyethyl cellulose are capable of forming separators exhibiting very high ionic conductivity with exceptional strength and shrinkage characteristics. Thus, a blend of two different polymers may be employed to provide a composition which can be used to form *in situ* separators having an outstanding combination of properties.

[0034] Kappa-carrageenan is a naturally occurring marine colloid. More specifically, kappa-carrageenan is a sulphur phycocolloid (a polysaccharide) occurring in algae. A major potential advantage of kappa-carrageenan as a separator is that it is a low-temperature thermoplastic gel, preferably having a melting point greater than 71°C. Other potential advantages are that it is non-toxic, water-soluble, very low in cost, and readily available commercially. The separators may be cast from a coating composition containing approximately 1 to 10 percent, and more desirably 2 to 5 percent, by weight of the composition. However, higher and lower concentrations may be used.

[0035] Hydroxyethyl cellulose is a non-ionic, water-soluble, cellulose ether. The potential advantages of hydroxyethyl cellulose as a battery separator material are that it is water-soluble, low cost, commercially available, can be chemically cross-linked (with divinylsulphone, for example) and is compatible with other aqueous based polymers. A suitable separator coating composition which can be used to form a battery separator may be prepared as a 5 weight percent mixture of hydroxyethyl cellulose in water, although higher and lower concentrations may also be used. Divinylsulphone cross-linking agent is desirably added to the coating composition in an amount of from about 0.05 to about 2% of the weight of the hydroxyethyl cellulose, and more desirably from about 0.10 to about 1 weight percent. In general, higher amounts of cross-linking agent provide separators which exhibit higher electrical resistance and greater strength at the expense of ionic conductivity.

[0036] Another material which has been found suitable for preparing a separator directly on a cathode surface is cellulose viscose. Cellulose viscose is a viscous liquid consisting of concentrated aqueous alkali containing a solution of cellulose/xanthate complex. It can be coagulated in dilute (e.g., 10%) sulphuric acid to form regenerated cellulose. The potential advantages of cellulose viscose are that it is water-soluble, low cost, stable to concentrated alkali, and has an existing performance record in alkaline batteries. Separators can be cast from solutions containing about 5 weight percent cellulose/xanthate complex, although higher and lower concentrations may also be used.

[0037] Examples of other materials which can be used in the preparation of the coating compositions which are applied to the cathode to form a separator include various synthetic polymers prepared as aqueous

dispersions. Examples include aqueous dispersions of cellulose, polyurethane, acrylic polymers, polyvinyl acetate, and epoxy polymers; and dispersions of cellulose in polar organic solvents such as N-methyl morpholine oxide.

[0038] The coating compositions may and often desirably contain fibres, such as wood pulp, polyolefin, cellulose, cotton, rayon, boron, boron carbide, boron nitride, carbon, aluminium silicate, and/or fused silica fibres. Polyolefin fibres include halogenated polyolefin fibres, such as those prepared from fluorinated polypropylene. The amount of fibre in the composition is desirably from about 3 % to about 50 %, and more preferably from about 3 % to about 20%, of the weight of the polymer or gel material in the composition. Fibres are included to provide physical barrier integrity, and to reinforce and structurally strengthen the separator.

[0039] Particularly preferred coating compositions are those comprising kappa-carrageenan, hydroxyethyl cellulose, and cellulose fibres. The hydroxyethyl cellulose, kappa-carrageenan, and cellulose fibres are preferably dispersed in water to form the separator coating composition. The weight ratio of hydroxyethyl cellulose to kappa-carrageenan is preferably from about 1:3 to 3:1, and more preferably from about 1:1 to about 3:1, although higher and lower ratios may also be used. The amount of hydroxyethyl cellulose and kappa-carrageenan in the coating composition may vary considerably, but is generally from about 1 % to about 10% by weight, although higher and lower concentrations may also be used.

[0040] Cross-linking agents such as divinylsulphone may be employed in amounts up to about 2% of the weight of the composition. Another suitable cross-linking agent which may be employed is trishydroxy methyl cyanurate, which is commercially available from American Cyanamid and sold under the trademark CYMEL®. The coating compositions have a solvent content greater than 50% by weight during application.

[0041] In a preferred embodiment, the coating composition is a polymer dispersion comprising hydroxyethyl cellulose in water and containing divinylsulphone cross-linking agent in an amount of from about 0.05 to about 2% of the weight of the composition.

[0042] In another preferred embodiment, the coating composition is a polymer dispersion comprising kappa-carrageenan, lambda-carrageenan, iota-carrageenan, hydroxymethyl cellulose, hydroxyethyl cellulose, hydroxypropyl cellulose, or a combination thereof.

[0043] In yet another preferred embodiment, the coating composition is comprised of kappa-carrageenan, hydroxyethyl cellulose, and divinylsulphone cross-linking agent, the weight ratio of hydroxyethyl cellulose to kappa-carrageenan is from about 1:3 to about 3:1, and the amount of cross-linking is from about 0.05 to about 2% of the weight of the composition. More preferably, the amount of hydroxyethyl cellulose and kappa-carrageenan in the coating composition is from about 1 % to

about 10 % by weight. Preferably, this coating composition further contains an amount of fibre which is from about 3 % to about 50 % of the weight of the composition.

5 [0044] The present invention will now be described with reference to the following nonlimiting examples:

EXAMPLES

10 Fabrication Of Functional Batteries

[0045] Three master batches of separator coating compositions were prepared. The first coating composition contained 5 % by weight kappa-carrageenan in water. The second coating composition contained 5 weight percent hydroxyethyl cellulose in water with 1 weight percent potassium hydroxide. The third coating composition was a 3:1 mixture of the kappa-carrageenan master batch to the hydroxyethyl cellulose master batch. The kappa-carrageenan and kappa-carrageenan hydroxyethyl cellulose blends were heated above 90°C to melt the kappa-carrageenan and were held between 90°C and 100°C in a double boiler. A stainless steel ram was fabricated that was 1mm (40 mils) smaller in diameter than the inside diameter of a D cell cathode. The ram or mandrel was mounted in a collet on a vertical milling machine. A V-block was positioned on a machine table such that when a D cell was clamped in the V-block the centre line of the ram was in line with the centre of the cell. A spindle stop on the machine was set so that the ram would stop approximately 1.6 mm (1/16 inch) above the bottom of the can. With this configuration, the formed separator was to be 0.5 mm (0.020 inches) thick on the cathode surface and 1.6 mm (0.062 inches) thick on the bottom. The separator could actually be significantly thinner than this. However, during the developmental work it was preferable to have a thicker separator than needed, to compensate for example for any tooling inaccuracies, cathode particle entrapment, or bubbles in the liquid separator. Separators were formed from the kappa-carrageenan coating composition and from the kappa-carrageenan/hydroxyethyl cellulose blend in the cells by filling the cells to the top with the liquid separator coating composition and lowering the ram into the cathode. As the ram entered the cathode, excess liquid flowed out. After the separator material cured or solidified, the ram was removed. In the case of the hydroxyethyl cellulose formulation, vinyl sulphone cross-linker was added and mixed prior to pouring the material into the cathodes. The filling and ram forming process was performed twice on each cell in order to fill any voids that might be caused by for example air bubbles, or uneven separator material flow. Anode paste was added to fill the cells to the top of the cathode and collector assemblies were placed on the cells.

[0046] Nine cells were formed with the kappa-carrageenan separator material. All of the cells had an initial voltage of from 1.51 to 1.64 volts. Seven functional cells

were put on 71°C shelf-life testing. Two of the cells had an open circuit voltage (OCV) above 1.2 after storage for 5 weeks at 71°C.

[0047] Four cells were made using the kappa-carrageenan/hydroxyethyl cellulose blend. Two of the cells had an initial voltage above 1.5. The other two cells have voltages below 1.2.

[0048] Based on these tests, it was determined that battery separator membranes made from kappa-carrageenan coating compositions and kappa-carrageenan/hydroxyethyl cellulose coating compositions can be used in alkaline cells. These tests also demonstrated that the ram moulding process for forming the separator membranes is workable.

Fabrication of AA Batteries

[0049] AA alkaline batteries were prepared as follows. A 5 weight percent solution of kappa-carrageenan in water was prepared. The kappa-carrageenan solution was held at 90°C in a hot water bath. A large syringe with a hypodermic needle was filled with the kappa-carrageenan solution. The kappa-carrageenan coating composition was introduced to the bottom of the AA can containing the cathode. The can containing the cathode was filled to the top with the kappa-carrageenan coating composition. This eliminated the need for accurately metering the kappa-carrageenan. During the moulding process the excess was allowed to flow over the top of the can. Immediately after the kappa-carrageenan was introduced, the moulding ram was lowered into the cathode and the kappa-carrageenan coating composition flowed between the outer surface of the ram and the inner surface of the cathode. After the coating composition solidified, the ram was raised, and the cathode was removed from the ram. Excess kappa-carrageenan material was removed from the area above the cathode shelf. Anode paste was introduced into the cathode having the separator formed directly thereon, and a collector assembly was placed on the can and pressed in place using a small hand press. The cells were tested for open circuit voltage immediately after fabrication and for a short period thereafter. The cells were put on 71°C shelf-testing and 71°C, 0.8 volts post-partial discharge (PPD) testing. Controls were made by adding anode paste to cathodes lined with conventional paper separators and by pressing collector assemblies in place.

[0050] One hundred and three (103) operational cells were made with kappa-carrageenan separators. All of the kappa-carrageenan separators were fabricated using the ram moulding technique. These tests proved that operational batteries could be fabricated with separator membranes that are made by applying a coating composition to the cathode surface and allowing the coating composition to solidify.

Fabrication of Alkaline Cells Having Kappa-Carrageenan/Hydroxyethyl

Cellulose Blend Separators

[0051] Two master batches were prepared, including a first containing 5 % kappa-carrageenan in water, and a second containing 5 % hydroxyethyl cellulose in water (both on a weight basis). The pH of the hydroxyethyl cellulose batch was increased to 12 by addition of solid potassium hydroxide. The batches were mixed in a ratio of three parts of the composition containing the kappa-carrageenan to one part of the composition containing the hydroxyethyl cellulose. The AA batteries were prepared in accordance with the method described above. Sixty (60) operational cells were made with the kappa-carrageenan/hydroxyethyl cellulose blend separators, and 50 controls were made with conventional paper separators. The open circuit voltages for the batteries containing the kappa-carrageenan/hydroxyethyl cellulose separators were comparable to conventional batteries containing a paper separator. Three (3) of the cells containing the ram moulded kappa-carrageenan/hydroxyethyl cellulose separators lasted 8 weeks with a final average open-circuit voltage reading of 1.236 volts. The remainder of the cells failed after 2 to 3 weeks. These results demonstrate that alkaline batteries can be successfully prepared with a separator which is formed by applying a coating composition to the cathode surface and allowing the coating composition to solidify.

Centrifugally Cast Separators

[0052] A kappa-carrageenan/hydroxyethyl cellulose blend as described above was successfully centrifugally cast on the inner surface of a cathode for a cylindrical AA alkaline cell. The AA cells were inserted into a support fixture that was mounted to the output shaft of a DC motor and rotated at approximately 20° to horizontal. The axis of rotation was coincident with the longitudinal axis of the cylindrical cell. The coating composition containing kappa-carrageenan and hydroxyethyl cellulose was introduced into the cathode using a syringe as previously described. The cell was then rapidly accelerated to 2500 rpm and held at that speed for approximately 2 minutes, causing the liquid to flow up the sides of the cathode and to solidify or set-up. In order to avoid complications of measuring the amount of liquid injected into the cell, the cells were overfilled. During the spinning operation, the excess liquid exited from the top of the cell. After the separators set-up, the cathodes were removed from the spinning fixtures, and additional potassium hydroxide was added. The anode paste was then added along with additional potassium hydroxide, and the collector was installed. Eleven (11) operational cells were produced by the centrifugal casting technique. This test demonstrated that centrifugal casting can be effectively used for applying a coating composition to a

cathode surface to form a separator directly on the cathode surface.

Polyvinyl Acetate Separators

[0053] The above centrifugal casting process was repeated using a polyvinyl acetate aqueous dispersion. Three (3) operational cells were made with polyvinyl acetate membranes.

Fabrication Of Cells Using Separator Coating Composition Containing Solid Cellulose Fibres

[0054] A master batch of 5 % kappa-carrageenan (weight basis) in water was prepared at 90°C. A master batch of 5 % hydroxyethyl cellulose (by weight) in 1 % potassium hydroxide (by weight) was prepared. The kappa-carrageenan composition and the hydroxyethyl cellulose composition were mixed in a 3:1 ratio at 90°C. To this blend was added 15 % cellulose fibre by weight. Ram moulding, as described above, was used for preparing AA cells having a separator formed from the coating composition containing kappa-carrageenan/hydroxyethyl cellulose/cellulose fibre. Seventy-seven (77) operational cells were prepared with the kappa-carrageenan/hydroxyethyl cellulose/cellulose fibre blend. Nine of ten batteries subjected to a 71°C shelf test were operational after 8 weeks, and four of five batteries subjected to a 0.8 volt PPD test were operational.

Claims

1. A battery (12) comprising first and second electrodes, an alkaline electrolyte, and an ionically conductive separator (18) disposed between the electrodes, the separator (18) being formed by applying a coating composition (10) to the surface of at least one of the electrodes and solidifying material contained in the coating composition (10), the coating composition (10) comprising a gel or polymer dispersed in a polar solvent, wherein the separator (18) has a solvent content greater than 50% by weight.
2. A battery (12) according to claim 1, wherein the coating composition (10) comprises kappa-carrageenan, lambda-carrageenan, iota-carrageenan, hydroxymethyl cellulose, hydroxyethyl cellulose, hydroxypropyl cellulose, or combination thereof, and preferably comprises kappa-carrageenan, hydroxyethyl cellulose, or a blend of kappa-carrageenan and hydroxyethyl cellulose.
3. A battery (12) according to claim 2, wherein the coating composition (10) comprises from about 1 to about 10 weight percent kappa-carrageenan.
4. A battery (12) according to claim 1, wherein the coating composition (10) comprises a synthetic polymer.
5. A battery (12) according to claim 4, wherein the synthetic polymer is polyvinyl acetate.
6. A battery (12) according to claim 4, wherein the synthetic polymer comprises polyurethane, acrylic polymer, epoxy polymer, or a combination thereof.
7. A battery (12) according to claim 1, wherein the coating composition (10) comprises cellulose viscose.
8. A battery (12) according to any preceding claim, wherein the coating composition (10) includes fibres, preferably fibres selected from cellulose, cotton, rayon, boron, boron carbide, boron nitride, aluminium silicate, fused silica fibres, wood pulp, and polyolefin fibres.
9. A battery (12) according to any preceding claim, wherein the coating composition (10) includes a cross-linking agent, preferably divinylsulphone or tris(hydroxymethyl) cyanurate.
10. A battery (12) according to any preceding claim, wherein the separator (18) occupies less than 10% of the volume of the battery.
11. A battery (12) according to any preceding claim, wherein the separator (18) has a solvent content greater than 90% by weight.
12. A battery (12) according to any preceding claim, wherein the separator (18) has controlled variation in thickness.
13. A battery (12) according to any preceding claim, wherein the separator (18) has sufficient elasticity to sustain at least 25 % expansion of the cathode (14) dimensions during discharge.
14. A battery (12) according to any preceding claim, wherein the coating composition (10) is a polymer blend comprising at least two different polymers.
15. A battery (12) according to claim 1, wherein the coating composition (10) comprises a thermoplastic gel, preferably a thermoplastic gel having a melting point greater than 71°C.
16. A battery (12) according to any preceding claim, wherein the material in the coating composition (10) is solidified by drying, curing, gelling, cross-linking, polymerisation, freezing, or a combination of these techniques.

17. A method of providing a separator (18) on an electrode for an alkaline battery (12), comprising:

applying a liquid aqueous coating composition (10) to an electrode surface, the coating composition (10) comprising a gel or polymer dispersed in a polar solvent; and
solidifying the coating composition (10) on said electrode surface to form a separator (18) membrane, wherein the separator (18) has a solvent content greater than 50% by weight.

18. A method according to claim 17, wherein the coating composition (10) is applied by introducing the coating composition (10) into the bottom of a cathode (14) and introducing a forming ram (16) into the cathode (14) to form an annular space between the interior surface of the cathode (14) and the outer surface of the ram (16) and to cause the coating composition (10) to flow up into said annular space, solidifying the coating composition (10) and removing the ram (16) from the cathode (14).

19. A method according to claim 17, wherein the coating composition (10) is applied to the cathode (14) surface by introducing a ram (20) having a coating composition outlet port (24) into the cathode (14), introducing the coating composition (10) into the cell through the port (24), causing the separator material to flow into an annular space between the ram (20) and the inner surface of the cathode (14), solidifying the coating composition (10) and removing the ram (20) from the cathode (14).

20. A method according to claim 17, wherein the coating composition (10) is applied to the surface of a cathode (14) by centrifugal casting, preferably by introducing the coating composition (10) into a cathode (14) cup disposed in a cylindrical can and rotating the cylindrical can at a high speed to cause the coating composition (10) to flow along the internal surface of the cathode (14) cup and solidify, the axis of rotation being coincident with the longitudinal axis of the cylindrical can, the axis of rotation of the cylindrical can in which the cathode (14) is disposed being at an angle between and including a vertical axis and a horizontal axis.

21. A method according to claim 17, wherein the coating composition (10) is applied by spraying.

22. A method according to any of claims 17 to 21, wherein the separator (18) has a solvent content greater than 90% by weight.

23. A method according to any of claims 17 to 22, wherein the coating composition (10) comprises kappa-carrageenan, lambda-carrageenan, iota-car-

rageenan, hydroxymethyl cellulose, hydroxyethyl cellulose, hydroxypropyl cellulose, or a combination thereof, and preferably comprises kappa-carrageenan, hydroxyethyl cellulose, or a combination of kappa-carrageenan and hydroxyethyl cellulose.

24. A method according to any of claims 17 to 22, wherein the coating composition (10) comprises a synthetic polymer.

25. A method according to claim 24, wherein the synthetic polymer is polyvinyl acetate.

26. A method according to claim 24, wherein the synthetic polymer is polyurethane, acrylic polymer, epoxy polymer, or a combination thereof.

27. A method according to any of claims 17 to 22, wherein the coating composition (10) comprises cellulose viscose.

28. A method according to any of claims 17 to 27, wherein the coating composition (10) includes fibres selected from cellulose, wool, silk, cotton, rayon, boron, boron carbide, boron nitride, carbon, aluminium silicate, fused silica fibres, wood pulp and polyolefin fibres.

29. A method according to any of claims 17 to 28 further comprising a cross-linking agent, preferably divinylsulphone or trishydroxymethyl cyanurate.

Patentansprüche

1. Batterie (12), umfassend erste und zweite Elektroden, ein alkalisches Elektrolyt, und einen ionisch leitenden Separator (18), der zwischen den Elektroden angeordnet ist, wobei der Separator (18) durch Anwenden einer Beschichtungsverbindung (10) auf die Oberfläche von wenigstens einer der Elektroden und Verfestigen von Material, das in der Beschichtungsverbindung (10) enthalten ist, gebildet wird, wobei die Beschichtungsverbindung (10) ein Gel oder Polymer umfasst, das/der in einem polaren Lösungsmittel verteilt ist, wobei der Separator (18) einen Lösungsmittelgehalt von größer als 50 Gewichts-% aufweist.

2. Batterie (12) nach Anspruch 1, wobei die Beschichtungsverbindung (10) umfasst: Kappa-Carrageenan, Lambda-Carrageenan, Iota-Carrageenan, Hydroxymethyl-Zellulose, Hydroxyethyl-Zellulose, Hydroxypropyl-Zellulose, oder eine Kombination davon, und vorzugsweise umfasst; Kappa-Carrageenan, Hydroxyethyl-Zellulose, oder ein Gemisch von Kappa-Carrageenan und Hydroxyethyl-Zellulose.

3. Batterie (12) nach Anspruch 2, wobei die Beschichtungsverbindung (10) von ungefähr 1 bis ungefähr 10 Gewichts-% Kappa-Carrageenan umfasst.
4. Batterie (12) nach Anspruch 1, wobei die Beschichtungsverbindung (10) einen synthetischen Polymer umfasst.
5. Batterie (12) nach Anspruch 4, wobei der synthetische Polymer Polyvinyl-Acetat ist.
6. Batterie (12) nach Anspruch 4, wobei der synthetische Polymer Polyurethan, einen akrylischen Polymer, einen Epoxidpolymer, oder eine Verbindung davon umfasst.
7. Batterie (12) nach Anspruch 1, wobei die Beschichtungsverbindung (10) eine Zellulose-Viskose umfasst.
8. Batterie (12) nach irgendeinem vorangehenden Anspruch, wobei die Beschichtungsverbindung (10) Fasern, vorzugsweise Fasern, die aus Zellulose, Baumwolle, Rayon, Bor, Borkarbid, Bornitrid, Aluminiumsilikat, verschmolzenen Siliziumdioxid-Fasern, einer Holzmasse, und Polyolefin-Fasern gewählt sind, einschließt.
9. Batterie (12) nach irgendeinem vorangehenden Anspruch, wobei die Beschichtungsverbindung (10) ein quervernetzendes Mittel, vorzugsweise Butadiensulphon oder Trishydroxymethyl-Zyanurat, einschließt.
10. Batterie (12) nach irgendeinem vorangehenden Anspruch, wobei der Separator (18) weniger als 10% des Volumens der Batterie belegt.
11. Batterie (12) nach irgendeinem vorangehenden Anspruch, wobei der Separator (18) einen Lösungs-mittelgehalt von größer als 90 Gewichts-% aufweist.
12. Batterie (12) nach irgendeinem vorangehenden Anspruch, wobei der Separator (18) eine kontrollierte Veränderung in der Dicke aufweist.
13. Batterie (12) nach irgendeinem vorangehenden Anspruch, wobei der Separator (18) eine ausreichende Elastizität aufweist, um wenigstens eine 25% Ausdehnung der Kathoden-(14)-Dimensionen während einer Entladung aushalten.
14. Batterie (12) nach irgendeinem vorangehenden Anspruch, wobei die Beschichtungsverbindung (10) ein Polymergemisch ist, welches wenigstens zwei unterschiedliche Polymere umfasst.
15. Batterie (12) nach Anspruch 1, wobei die Beschichtungsverbindung (10) ein thermoplastisches Gel umfasst, vorzugsweise ein thermoplastisches Gel mit einem Schmelzpunkt von größer als 71°C.
16. Batterie (12) nach irgendeinem vorangehenden Anspruch, wobei das Material in der Beschichtungsverbindung (10) durch ein Trocknen, Aushärten, Gelieren, Quervernetzen, eine Polymerisation, eine Einfrierung, oder eine Kombination von diesen Techniken verfestigt wird.
17. Verfahren zum Bereitstellen eines Separators (18) auf einer Elektrode für eine alkalische Batterie (12), umfassend die folgenden Schritte:

Anwenden einer flüssigen wasserhaltigen Beschichtungsverbindung (10) auf eine Elektrodenoberfläche, wobei die Beschichtungsverbindung (10) ein Gel oder Polymer aufweist, das in einem polaren Lösungsmittel verteilt ist; und
Verfestigen der Beschichtungsverbindung (10) auf der Elektrodenoberfläche, um eine Separator-(18)-Membran zu bilden, wobei der Separator (18) einen Lösungsmittelgehalt von größer als 50 Gewichts-% aufweist.
18. Verfahren nach Anspruch 17, wobei die Beschichtungsverbindung (10) durch Einführen der Beschichtungsverbindung (10) in den Boden einer Kathode (14) und Einführen einer Bildungsramme (16) in die Kathode (14), um einen ringförmigen Raum zwischen der inneren Oberfläche der Kathode (14) und der äußeren Oberfläche der Ramme (16) zu bilden und um zu bewirken, dass die Beschichtungsverbindung (10) in den ringförmigen Raum nach oben fließt, Verfestigen der Beschichtungsverbindung (10) und Entfernen der Ramme (16) von der Kathode (14) angewendet wird.
19. Verfahren nach Anspruch 17, wobei die Beschichtungsverbindung (10) auf die Kathode-(14)-Oberfläche durch Einführen einer Ramme (20) mit einer Beschichtungsverbindungs-Auslassöffnung (24) in die Kathode (14) hinein. Einführen der Beschichtungsverbindung (10) in die Zelle hinein durch die Öffnung (24), Bewirken, dass das Separatormaterial in einen ringförmigen Raum zwischen der Ramme (20) und der inneren Oberfläche der Kathode (14) fließt, Verfestigen der Beschichtungsverbindung (10) und Entfernen der Ramme (20) von der Kathode (14), angebracht wird.
20. Verfahren nach Anspruch 17, wobei die Beschichtungsverbindung (10) auf die Oberfläche einer Kathode (14) durch eine Zentzifugal-Benetzung angewendet wird, vorzugsweise durch Einführen der Be-

schichtungsverbindung (10) in eine Kathoden-(14)-Kappe, die in einem zylindrischen Behälter angeordnet ist, und Drehen des zylindrischen Behälters bei einer hohen Geschwindigkeit, um zu bewirken, dass die Beschichtungsverbindung (10) entlang der inneren Oberfläche der Kathoden-(14)-Kappe fließt und sich verfestigt, wobei die Drehungsachse mit der Längsachse des zylindrischen Behälters übereinstimmt, wobei die Drehungsachse des zylindrischen Behälters, in dem die Kathode (14) angeordnet ist, unter einem Winkel zwischen und einschließlich einer vertikalen Achse und einer horizontalen Achse ist.

21. Verfahren nach Anspruch 17, wobei die Beschichtungsverbindung (10) durch eine Besprühung angebracht wird.
22. Verfahren nach irgendeinem der Ansprüche 17 bis 21, wobei der Separator (18) einen Lösungsmittelgehalt von größer als 90 Gewichts-% aufweist.
23. Verfahren nach irgendeinem der Ansprüche 17 bis 22, wobei die Beschichtungsverbindung (10) umfasst: Kappa-Carrageenan, Lambda-Carrageenan, Iota-Carrageenan, Hydroxymethyl-Zellulose, Hydroxyethyl-Zellulose, Hydroxypropyl-Zellulose, oder eine Kombination davon, und vorzugsweise umfasst: Kappa-Carrageenan, Hydroxyethyl-Zellulose, oder ein Gemisch von Kappa-Carrageenan und Hydroxyethyl-Zellulose.
24. Verfahren nach irgendeinem der Ansprüche 17 bis 22, wobei die Beschichtungsverbindung (10) einen synthetischen Polymer umfasst.
25. Verfahren nach Anspruch 24, wobei der synthetische Polymer ein Polyvinylacetat ist.
26. Verfahren nach Anspruch 24, wobei der synthetische Polymer Polyurethan, einen akrylischen Polymer, einen Epoxidpolymer, oder eine Verbindung davon umfasst.
27. Verfahren nach irgendeinem der Ansprüche 17 bis 22, wobei die Beschichtungsverbindung (10) eine Zellulose-Viskose umfasst.
28. Verfahren nach irgendeinem der Ansprüche 17 bis 27, wobei die Beschichtungsverbindung (10) Fasern, vorzugsweise Fasern, die aus Zellulose, Baumwolle, Rayon, Bor, Borkarbid, Bomitrid, Aluminiumsilikat, verschmolzenen Siliziumdioxid-Fasern, einer Holzmasse, und Polyolefin-Fasern gewählt sind, einschließt.
29. Verfahren nach irgendeinem der Ansprüche 17 bis 28, ferner umfassend ein quervernetzendes Mittel,

vorzugsweise Divinylsulphon oder Trishydroxymethyl-Zyanurat.

5 Revendications

1. Une batterie (12) comprenant une première et une seconde électrode, un électrolyte alcalin et un séparateur conducteur ionique (18) disposé entre les électrodes, le séparateur (18) étant formé en appliquant une composition de revêtement (10) à la surface d'au moins une des électrodes et en solidifiant le matériau contenu dans la composition de revêtement (10), la composition de revêtement (10) comprenant un gel ou un polymère dispersé dans un solvant polaire, dans laquelle le séparateur (18) possède un contenu de solvant supérieur à 50% en poids.
2. Une batterie (12) selon la revendication 1, dans laquelle la composition de revêtement (10) comprend de la kappa-carraghénine, de la lambda-carraghénine, de la iota-carraghénine, de l'hydroxyméthylcellulose, de l'hydroxyéthylcellulose, de l'hydroxypropylcellulose, ou leur combinaison, et comprend préférentiellement de la kappa-carraghénine, de l'hydroxyéthylcellulose, ou un mélange de kappa-carraghénine et d'hydroxyéthylcellulose.
3. Une batterie (12) selon la revendication 2, dans laquelle la composition de revêtement (10) comprend d'environ 1 à environ 10 pour-cent en poids de kappa-carraghénine.
4. Une batterie (12) selon la revendication 1, dans laquelle la composition de revêtement (10) comprend un polymère synthétique.
5. Une batterie (12) selon la revendication 4, dans laquelle le polymère synthétique est l'acétate de polyvinyle.
6. Une batterie (12) selon la revendication 4, dans laquelle le polymère synthétique est constitué de polyuréthane, de polymère acrylique, de polymère époxy, ou une combinaison de ceux-ci.
7. Une batterie (12) selon la revendication 1, dans laquelle la composition de revêtement (10) comprend de la viscose de cellulose.
8. Une batterie (12) selon une quelconque revendication précédente, dans laquelle la composition de revêtement (10) inclut des fibres, préférentiellement des fibres sélectionnées parmi la cellulose, le coton, la rayonne, le bore, le carbure de bore, le nitrure de bore, le silicate d'aluminium, les fibres de silice fondue, la pâte de bois et les fibres polyoléfinées.

9. Une batterie (12) selon une quelconque revendication précédente, dans laquelle la composition de revêtement (10) inclut un agent de réticulation, préfé-
rablement le divinylsulfone ou le trishydroxyméthyl-
cyanurate. 5
10. Une batterie (12) selon une quelconque revendica-
tion précédente, dans laquelle le séparateur (18)
occupe moins de 10% du volume de la batterie. 10
11. Une batterie (12) selon une quelconque revendica-
tion précédente, dans laquelle le séparateur (18)
possède un contenu de solvant supérieur à 90% en
poids.
12. Une batterie (12) selon une quelconque revendica-
tion précédente, dans laquelle le séparateur (18)
possède une variation contrôlée en épaisseur.
13. Une batterie (12) selon une quelconque revendica-
tion précédente, dans laquelle le séparateur (18)
possède une élasticité suffisante pour supporter
une expansion d'au moins 25 % des dimensions de
la cathode (14) durant la décharge. 20
14. Une batterie (12) selon une quelconque revendica-
tion précédente, dans laquelle la composition de re-
vêtement (10) est un mélange de polymère compren-
ant au moins deux polymères différents. 25
15. Une batterie (12) selon la revendication 1, dans la-
quelle la composition de revêtement (10) comprend
un gel thermoplastique, préféablement un gel ther-
moplastique possédant un point de fusion supérieur
à 71°C. 30
16. Une batterie (12) selon une quelconque revendica-
tion précédente, dans laquelle le matériau dans la
composition de revêtement (10) est solidifié par sé-
chage, cuisson, gélification, réticulation, polymé-
risation, surgélation, ou une combinaison des ces
techniques. 35
17. Un procédé de réalisation d'un séparateur (18) sur
une électrode pour une batterie alcaline (12), com-
prenant: 40

l'application d'une composition de revêtement
aqueuse liquide (10) à une surface d'électrode,
la composition de revêtement (10) comprenant
un gel ou un polymère dispersé dans un solvant
polaire; et

la solidification de la composition de revête-
ment (10) sur ladite surface d'électrode pour
former une membrane de séparateur (18),
dans laquelle le séparateur (18) possède un
contenu de solvant supérieur à 50% en poids. 55
18. Un procédé selon la revendication 17, dans lequel
la composition de revêtement (10) est appliquée en
introduisant la composition de revêtement (10)
dans le fonds d'une cathode (14) et en introduisant
un piston de moulage (16) dans la cathode (14)
pour former un espace annulaire entre la surface
intérieure de la cathode (14) et la surface extérieure
du piston (16) et pour provoquer l'écoulement vers
le haut de la composition de revêtement (10) dans
ledit espace annulaire, en solidifiant la composition
de revêtement (10) et en retirant le piston (16) de
la cathode (14).
19. Un procédé selon la revendication 17, dans lequel
la composition de revêtement (10) est appliquée à
la surface de la cathode (14) en introduisant un pis-
ton (20) possédant un orifice de sortie (24) de com-
position de revêtement dans la cathode (14), en in-
troduisant la composition de revêtement (10) dans
la pile à travers l'orifice (24), en provoquant l'écou-
lement du matériau séparateur dans un espace an-
nulaire entre le piston (20) et la surface intérieure
de la cathode (14), en solidifiant la composition de
revêtement (10) et en retirant le piston (20) de la
cathode (14).
20. Un procédé selon la revendication 17, dans lequel
la composition de revêtement (10) est appliquée à
la surface d'une cathode (14) par coulage centrifuge,
préféablement en introduisant la composition
de revêtement (10) dans une cavité de cathode (14)
disposée dans un boîtier cylindrique et en faisant
tourner le boîtier cylindrique à haute vitesse pour
provoquer l'écoulement du matériau de revêtement
(10) le long de la surface interne de la cavité de ca-
thode (14) et sa solidification, l'axe de rotation coïn-
citant avec l'axe longitudinal du boîtier cylindrique,
l'axe de rotation du boîtier cylindrique dans lequel
la cathode (14) est disposée en formant un angle
intermédiaire et incluant un axe vertical et un axe
horizontal.
21. Un procédé selon la revendication 17, dans lequel
la composition de revêtement (10) est appliquée
par pulvérisation.
22. Un procédé selon une quelconque des revendica-
tions 17 à 21, dans lequel le séparateur (18) pos-
sède un contenu de solvant supérieur à 90% en
poids.
23. Un procédé selon une quelconque des revendica-
tions 17 à 22, dans lequel la composition de revê-
tement (10) comprend de la kappa-carraghénine,
de la lambda-carraghénine, de la iota-carraghéni-
ne, de l'hydroxyméthylcellulose, de l'hydroxyéthyl-
cellulose, de l'hydroxypropylcellulose, ou une com-
binaison de celles-ci, et comprend préféablement

de la kappa-carraghénine, de l'hydroxyéthylcellulose, ou un mélange de kappa-carraghénine et d'hydroxyéthylcellulose.

24. Un procédé selon une quelconque des revendications 17 à 22, dans lequel la composition de revêtement (10) comprend un polymère synthétique. 5
25. Un procédé selon la revendication 24, dans lequel le polymère synthétique est l'acétate de polyvinyle. 10
26. Un procédé selon la revendication 24, dans lequel le polymère synthétique est constitué de polyuréthane, de polymère acrylique, de polymère époxy, ou une combinaison de ceux-ci. 15
27. Un procédé selon une quelconque des revendications 17 à 22, dans lequel la composition de revêtement (10) comprend de la viscose de cellulose. 20
28. Un procédé selon une quelconque des revendications 17 à 27, dans lequel la composition de revêtement (10) inclut des fibres sélectionnées parmi la cellulose, la laine, la soie, le coton, la rayonne, le bore, le carbure de bore, le nitrure de bore, le carbone, le silicate d'aluminium, les fibres de silice fondue, la pâte de bois et les fibres polyoléfines. 25
29. Un procédé selon une quelconque des revendications 17 à 28 comprenant en outre un agent de réticulation, préférablement le divinylsulfone ou le trishydroxyméthylcyanurate. 30

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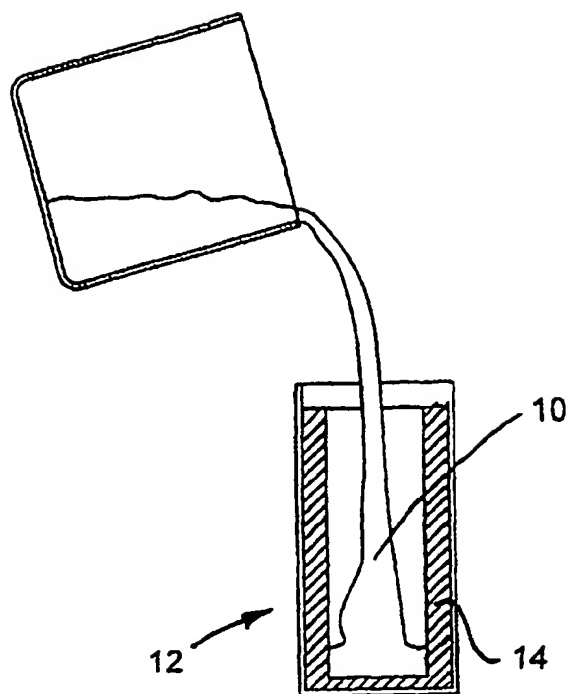


Fig. 1

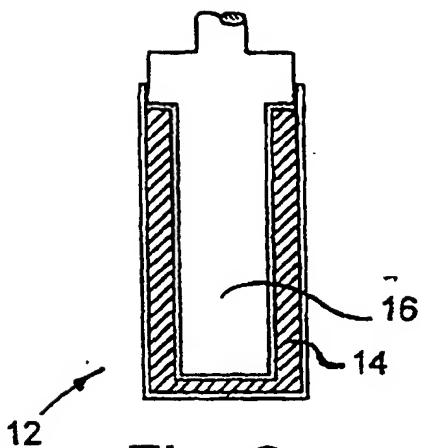


Fig. 2

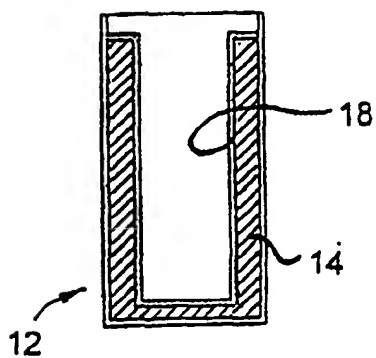


Fig. 3

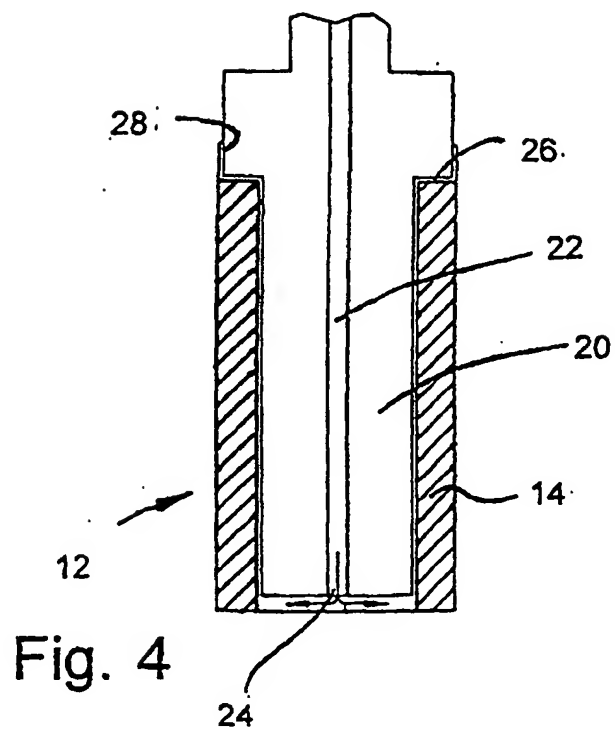


Fig. 4

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